

Date: Tuesday, 3/11/2008 10:28:47 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR RH
Job Number : 37782	
Estimate Number : 11225	
P.O. Number :	Part Number : D32803
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D3280 REV B C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / 1 Type : THERMOFORMING	Drawing Revision : B C
Previous Run : 37105	Material :
Written By :	Due Date : 4/4/2008 Qty: 5 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM	
Est RevB 07.09.12 Thermoform in house DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F6006 701	lexan black
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MLEX S093 F600602 2008/3/16



Comment: Qty.: 4.0000 sf(s)/Unit Total: 20.0000 sf(s) 106751 BB.
 lexan black M 107891

PTO →

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/03/12 X5

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 012

Dwg. Rev. C

Folio Rev. B

BB 08/03/12 X5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/03/12 X5

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

BB 08/03/12 X5

1) Trim to Finished Dimensions

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0803.12	1	Material Changed to MEXS 093 F600602	WZ	08.03.12	5	LE 08-03-13	08/03/13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: HD Date: 08/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 10:28:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR RH

Job Number: 37782

Part Number: D32803

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/03/18

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/18 (X5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

272

8/3/18

SD

(5X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/18 (5)

Job Completion



2008/3/18

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37782
Description: R22 Floor Protector, RH		Part Number:	D3280-3
Inspection Dwg: D3280 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>EB</u>	Date: <u>08/03/13</u>
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TRIMMING SECTION

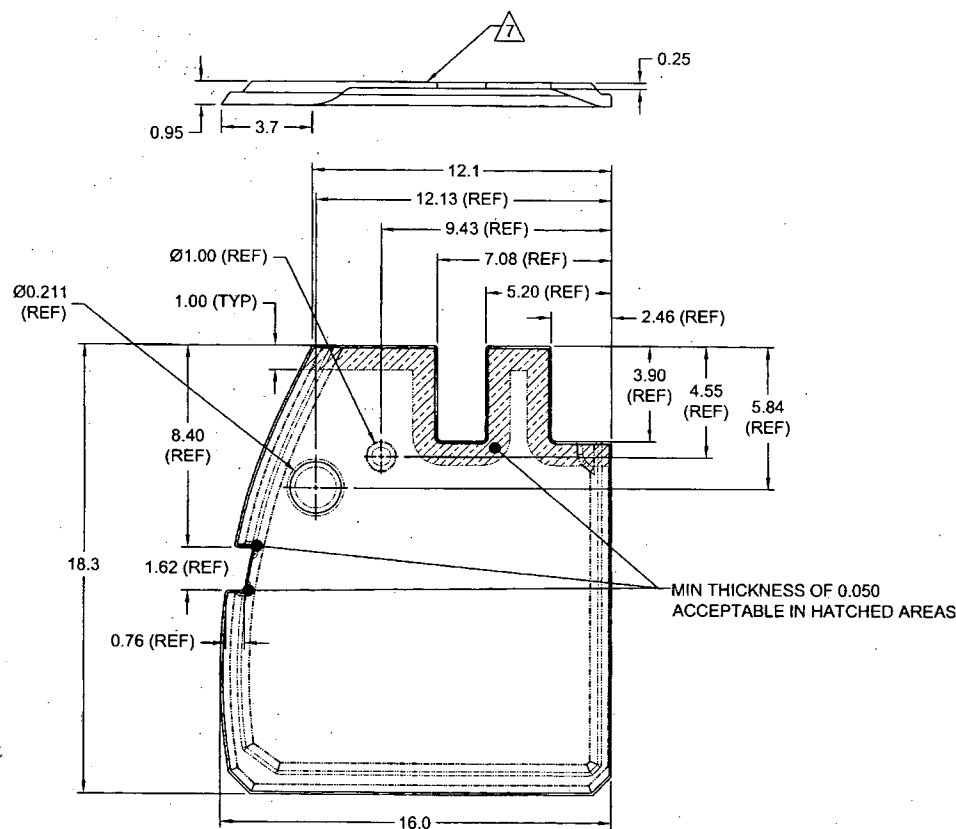
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.375	✓			
15.8	+/-0.100	15.8	✓			
12.1	+/-0.100	12.0	✓			
0.95	+/-0.030	0.956	✓			
0.25	+/-0.030	0.260	✓			

Measured by: <u>DK</u>	Date: <u>08.03.13</u>
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Audited by: <u> </u>	Date: <u>08/03/13</u>
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Prototype Approval: <u>N/A</u>	Date: <u>N/A</u>
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Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL <u> </u>	<u>DK</u>



D3280-1 FLOOR PROTECTOR

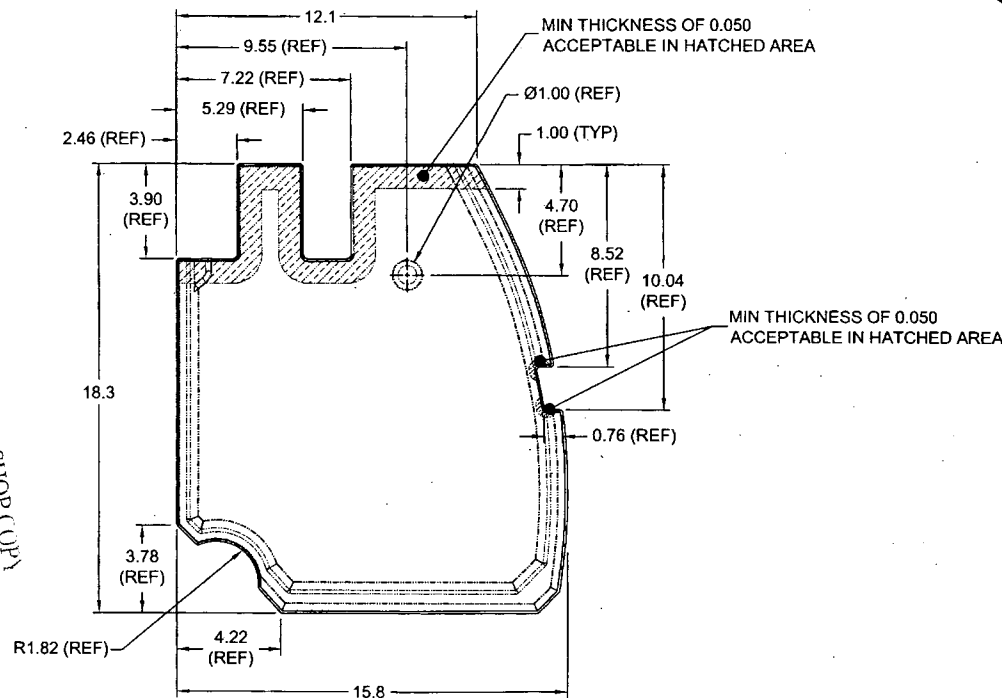
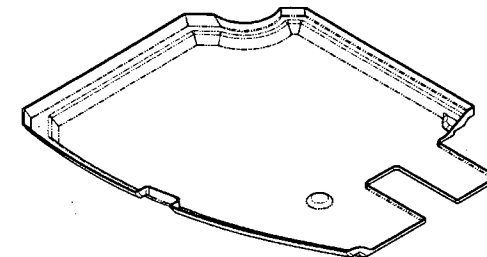
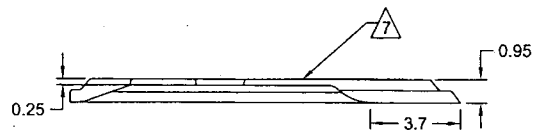
D3280-1 NOTES:

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

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WITHOUT NOTICE
WORK ORDER
NO. 37782
RELEASED
07-11-06

C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	LE		
CHECKED	PA		
MFG. APPR.	PA		
APPROVED	SH		
DE APPR.	SH		
DATE	07.10.12		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3280	REV. C SHEET 1 OF 2
TITLE FLOOR PROTECTOR	SCALE NTS
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D3280-3 FLOOR PROTECTOR

NO. 37782
WORK ORDER
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SHOP COPY

RELEASED
07-11-06

D3280-3 NOTES:

- 1) THERMOFORM WITH MOLD D3280-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS. 120 F6006-02) *0.093 thick*
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-3" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN	<i>LE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AM</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>ET</i>	D3280	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	FLOOR PROTECTOR	NTS
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